









Work Order ID 67175

Wednesday, March 09, 2011 12:58:13 PM


Page 1

Item ID: D2421 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bearpaw, 900
Start Date: 3/9/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/16/2011 Req'd Qty: 4.00  Customer:
Reference:
Approvals: Process Plan:  Date: 11-03-9 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2421	Rev F2								

120 0.00
 FLOW WATER JET
Waterjet Memo 0.00
FLOW CNC Waterjet Cut Blank as per file D2421 _BLANK

B 11-3-11

130 0.00
 HAAS CNC VERTICAL MACHINING #1
HAAS 1 Memo 0.00
HAAS CNC vertical machine #1

11/03/21

- 1-Inspect material for defects or damage prior to machining
- 2-Machine as per Folio FA124 and Dwg D2421
- Identify as D2421
- 3-Deburr

11/03/21

11/03/21

Butler
Pryor

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67175

Wednesday, March 09, 2011 12:58:14 PM



Page 2

Item ID: D2421

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 900

Start Date: 3/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11/03/21

4

0



QC

Memo

0.00

Quality Control

12

150

QC8- Inspect parts - second check

0.00

H a 11/03/22

4

0



QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PP67174

0.00

Packaging

11/03/22 (4)

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Page 3

Item ID: D2421

Accept

Revision ID:

Item Name: Bearpaw, 900

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Required Date: 3/16/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22

CL 11/03/22

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Picklist Print

Wednesday, March 09, 2011 12:58:20 PM

Page 1

Work Order ID: 67175

Parent Item: D2421

Parent Item Name: Bearpaw, 900



Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

352.1000

4

16



B11-3-11

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT

352.1

115955

38.8

116554

108.3

116796

12

116797

193

116797

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67175
Description: Bearpaw		Part Number:	D2421
Inspection Dwg: D2421	Rev: F2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.20	+/-0.030	190	/		vern. J1-3	
B	0.95	+/-0.030	945	/		-	
C	0.45	+/-0.010	450	/		-	
D	0.07 x 45°	+0.030/-0.010	0.7 x 45°	/		-	
E	0.69	+/-0.030	690	/		-	
F	0.38	+/-0.010	381	/		mic 18-120	
G	0.44 - 0.47	+/-0.000	455	/		-	
H	R0.25	+/-0.030	250	/		R-G	
I	0.19 x 45°	+/-0.030	180 x 45°	/		-	
J	23.00	+/-0.030	23.00	/		m-tape	
K	Ø0.260	+0.005/-0.000	260	/		-	
L	Ø0.93	+/-0.030	925	/		-	
M	0.30	+/-0.030	320	/		-	
N	4.50	+/-0.030	4.530	/		-	
O	9.50	+/-0.030	9.500	/		vern mic-02	
P	1.00	+/-0.030	1.00	/		-	
Q	14.750	+/-0.010	14.750	/		-	
R	0.38	+/-0.030	381	/		-	
S	4.54	+/-0.010	4.540	/		-	
T	19.00	+/-0.030	19.00	/		m-tape	

Measured by:	J	Audited by:	H.A	Prototype Approval:	N/A
Date:	11/03/21	Date:	11/03/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	04.11.29	Revised dimension M	KJ/JLM	

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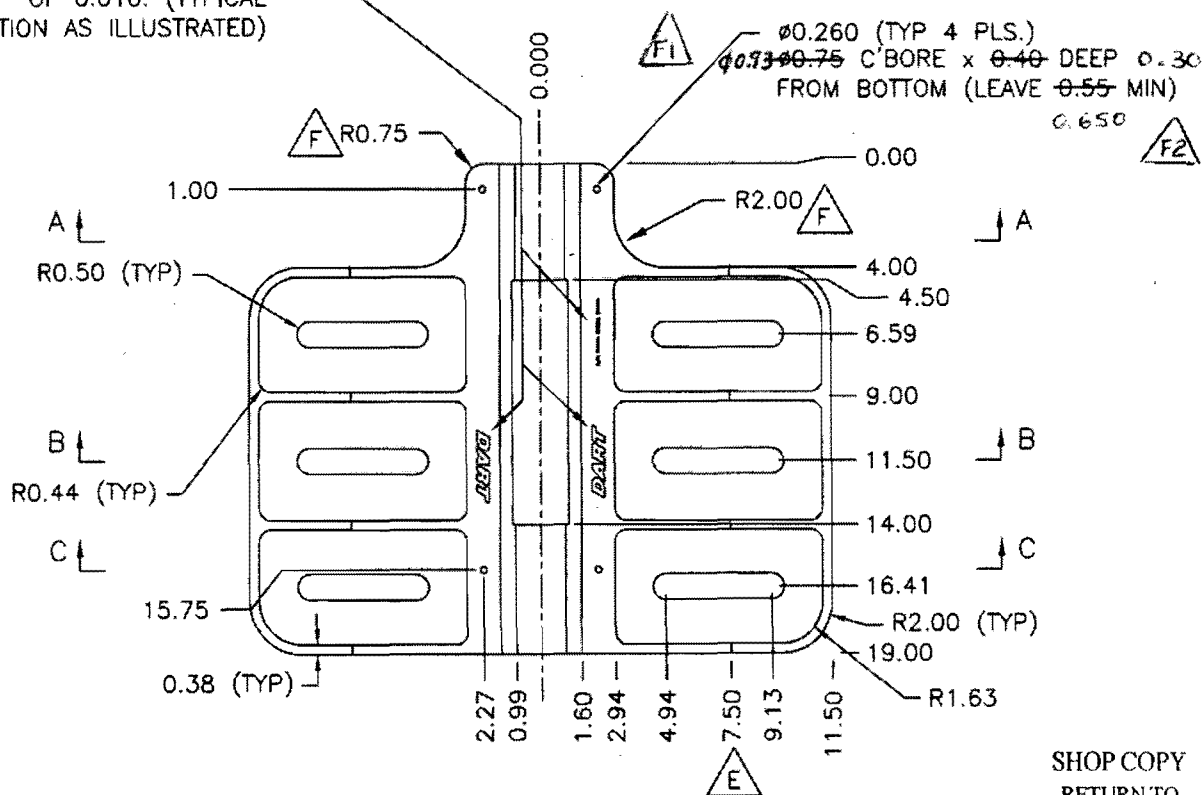
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NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF		APPROVED 		DRAWING NO. D2421 REV. F SHEET 1 OF 2	
DATE 01.03.12		TITLE BEARPAW		SCALE 1:7	
A	95.04.24	NEW ISSUE			
B	95.11.28	CHANGED NUMBER OF HOLES			
C	97.06.19	ADDED MATERIAL SPECIFICATION			
D	98.08.11	DIM MODIFICATIONS			
E	00.03.01	R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155			
F	01.03.12	MODIFY FWD END			
F1	RF 03.01.13	Ø 0.93 WAS Ø 0.75; R0.19 WAS R0.38; 0.19 WAS 0.25			
F2	RF 04.11.03	0.30 WAS 0.40 ; 0.650 WAS 0.55			

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



SYMMETRIC ABOUT CENTER LINE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. C-7175
11-039

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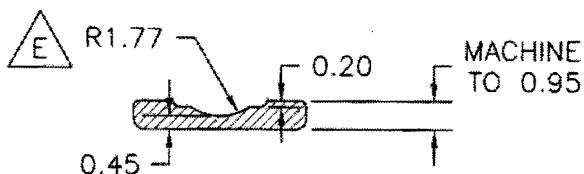
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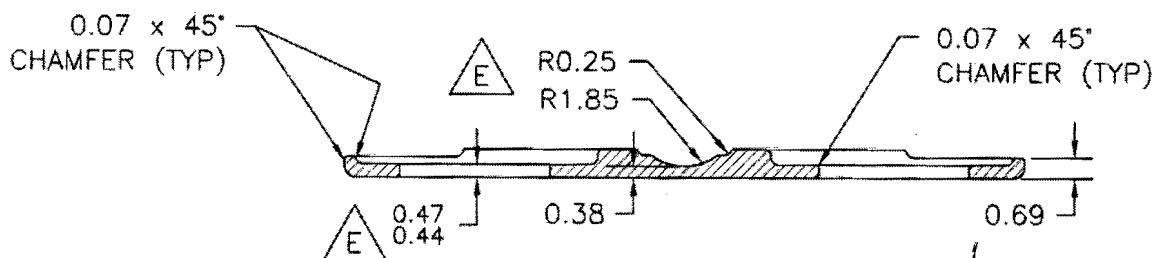


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED #	DRAWING NO. D2421	REV. F SHEET 2 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:6

RELEASED
01.03.14 #

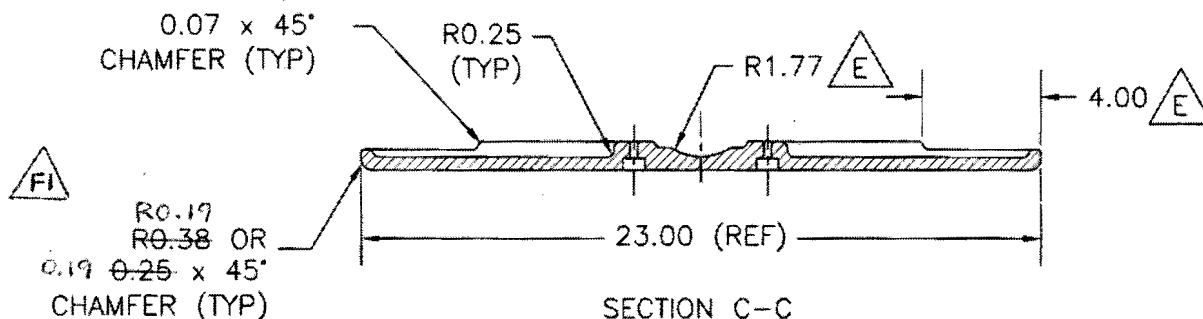


SECTION A-A



SECTION B-B

w/o 42175



SECTION C-C

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